

Date: Tuesday, 10/17/2006 11:19:53 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD  
 Job Number : 29038  
 Estimate Number : 10313  
 P.O. Number : N/A Part Number : D26483  
 This Issue : 10/17/2006 S.O. No. : N/A Drawing Number : D2648 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : D  
 Previous Run : 28249 Material : N/A  
 Written By : \_\_\_\_\_ Due Date : 10/30/2006 Qty: 50 Um: Each  
 Checked & Approved By : KJ 06 10 17  
 Comment : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF  
 Est Rev:F Now on Waterjet 06-08-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.9375 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: m9131 ml 06 12 05 (50)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

\*\*\*\*\*CUT WITH FILE D2648-1\*\*\*\*\* (50)

Dwg Rev: D

Prog Rev: D ml 06 12 05

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE (50)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK ml 06/12/06 (50)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Dec 08/06 49 50 kmj  
Dec 11/06 50 kmj  
ac

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/08

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:19:54 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 29038

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 06/12/19

(50)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

m102885

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

MF 07/01/02

(50)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 07/01/03

(50)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 07/01/03

(50)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FR/am 07/01/04

(50)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 07/01/04

(50)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F17

FC 07/01/04

(50)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A 07.01.05

U 07.01.05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

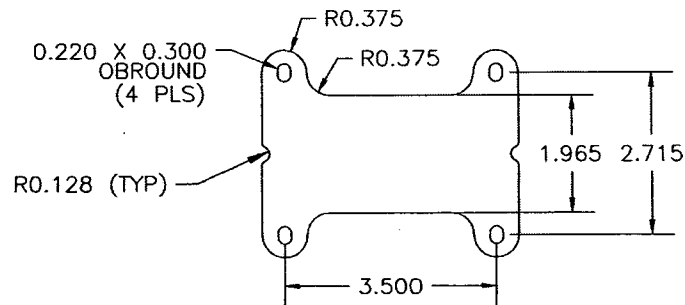
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

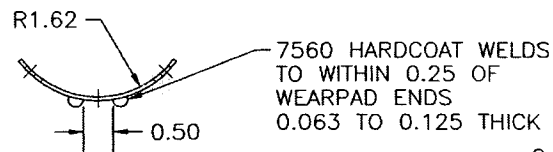
NOTE: Date & initial all entries



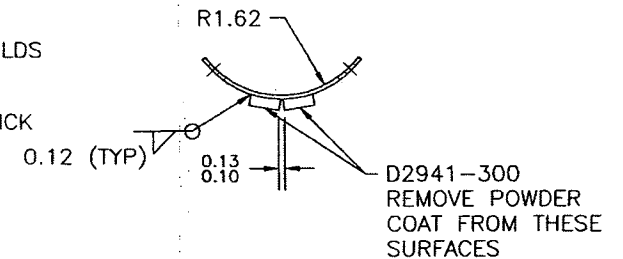
# D2648-1 FLAT PATTERN



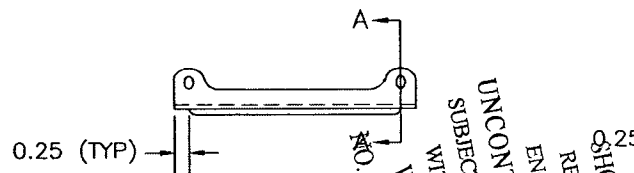
## SECTION A-A



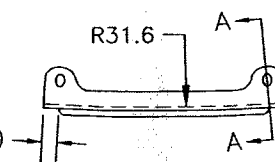
## SECTION B-B



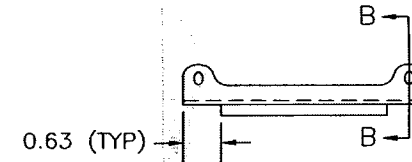
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
99.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
NO. 29038  
WORK ORDER

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	RF	DRAWING NO. D2648
DATE	99.11.17	TITLE WEARPAD
		REV. D SHEET 1 OF 1 SCALE 1:2